

Work Order ID 63184

Friday, October 22, 2010 2:56:29 PM



Page 1

Item ID: D2346

Accept



Setup Start



Revision ID:

Item Name: Spacer

Stop



Start Date: 10/25/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 10/27/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan: MF

Date: 10-10-28

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2346	Rev B

100



Hardinge

Hardinge CNC Lathe Small

Hardinge CNC LATHE SMALL

Memo

Machine as per folio FA198□Debur

0.00

0.00

20

0

J.F.S. 10/10/26

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

20

0

J.F.S. 10/10/26

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

20

0

B.A 10/10/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00 BR 10-10-26.

Memo

0.00

20

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

10/27/27 (20)

150



Packaging

Packaging

Identify as per dwg & Stock Location: 011

0.00

Memo

0.00

10/27/27 20

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/20/27 JH

N 10.10.27

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 63184



Parent Item: D2346



Parent Item Name: Spacer

Start Date: 10/25/2010

Required Date: 10/27/2010

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP G02.03.05 Re-format to machine in house NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.375W.035		Purchased	No			100	f	241.2904	0.1042	2.193684			
6061-T6 RD Tube .375 x.035W													



J.F.S. 10/10/20

Location

MAT014

104913

112652

Loc Qty

241.2904

37.2904

204

Loc Code

2.1936 (20)

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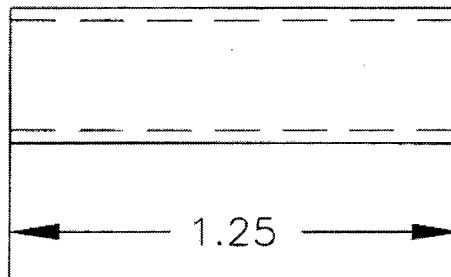
DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2346	REV. B SHEET 1 OF 1
DATE 99.12.15		TITLE SPACER	SCALE 2:1
A	95.01.05	NEW ISSUE	
B	99.12.15	ADD FINISHING	

RELEASED
99.12.21 DS
UNDER REVIEW

01.03.15 CP

DESIGN OK, BUT CHECK WITH
JB BEFORE MANUFACTURE

63184



MATERIAL: 6061-T6 (WW-T-700/6) 0.375 DIA x 0.035 WALL
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
BREAK SHARP EDGES 0.010 TO 0.020

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